

Date: Friday, 6/29/2007 11:17:51 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: TUBE	
Job Number	: 33260		Part Number	: D22825	
Estimate Number	: 11175		Drawing Number	: D2282 REV E	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	6/29/2007	S.O. No. : N/A	Drawing Revision	: E	
Prsht Rev.	NC		Material	: N/A	
First Issue	N/A	Type : MACHINED PARTS	Due Date	7/12/2007	Qty: 100 Um: Each
Previous Run	28355				
Written By					
Checked & Approved By					
Comment	Est Rev:A	Removed from 9 Digit	05-12-02	JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304R0750	Inventory
		 Comment: Qty.: 0.1891 f(s)/Unit Total : 18.9063 f(s) <i>S.P</i> Material: AISI 304 Stainless Steel Ø0.750(M304R0.750) Batch <i>M104934</i> <i>DSP 07/07/09</i> <i>RQ 07/07/10</i>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		 Comment: HARDINGE CNC LATHE SMALL
3.0	QC2	1-Turn as per Dwg D2282 and Folio FA189
		 2-Deburr <i>DSP 07/07/09</i> <i>RQ 07/07/10</i>
4.0	MILLING CONVA. <i>lucas</i>	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>DSP 07/07/09</i> <i>RQ 07/07/10 (208)</i>
5.0	QC2	CONVENTIONAL MILLING MACHINE
		 Comment: CONVENTIONAL MILLING MACHINE Mill Arc as per Dwg D2282 <i>JL / S.P 07/07/11</i>
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>JL / S.P 07/07/11</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: TUBE

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC8

SECOND CHECK



Comment: SECOND CHECK

Mon 07/07/12 100

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Mon 07/13 100

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.16 AJ

Job Completion



U 07.07.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33260
Description: Handle Tube	Part Number:	D2282-5
Inspection Dwg: D2282	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

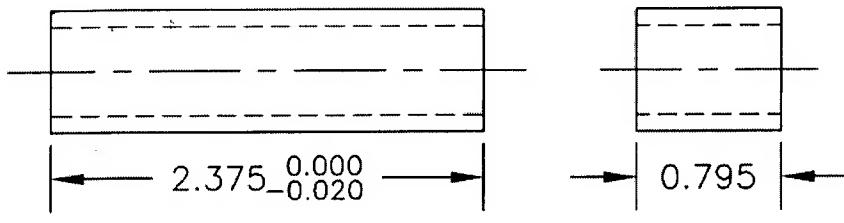
X First Article Prototype

Measured by:	DSR/SB/PR	Audited by:	AMC	Prototype Approval:	N/A
Date:	07/07/09	Date:	07/07/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
B	05.04.19	Dimensions & tolerances changed	KJ/JLM	
C	06.03.15	Dimensions & tolerances revised per Dwg Rev E	KJ/JLM	



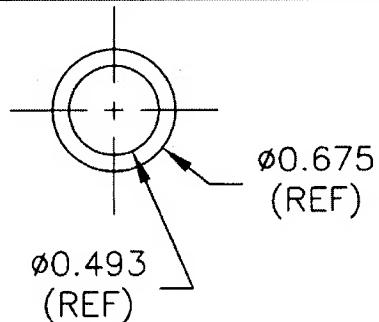
DESIGN BW	DRAWN BY <i>EP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>IP</i>	APPROVED <i>1000</i>	DRAWING NO. D2282
DATE 05.06.07	TITLE	SCALE 1:1
	HANDLE TUBES	
A	94.10.14	NEW ISSUE
B	95.03.23	RE-DESIGN
C	97.10.20	CORRECTED NUMBERING SCHEME
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030



D2282-3

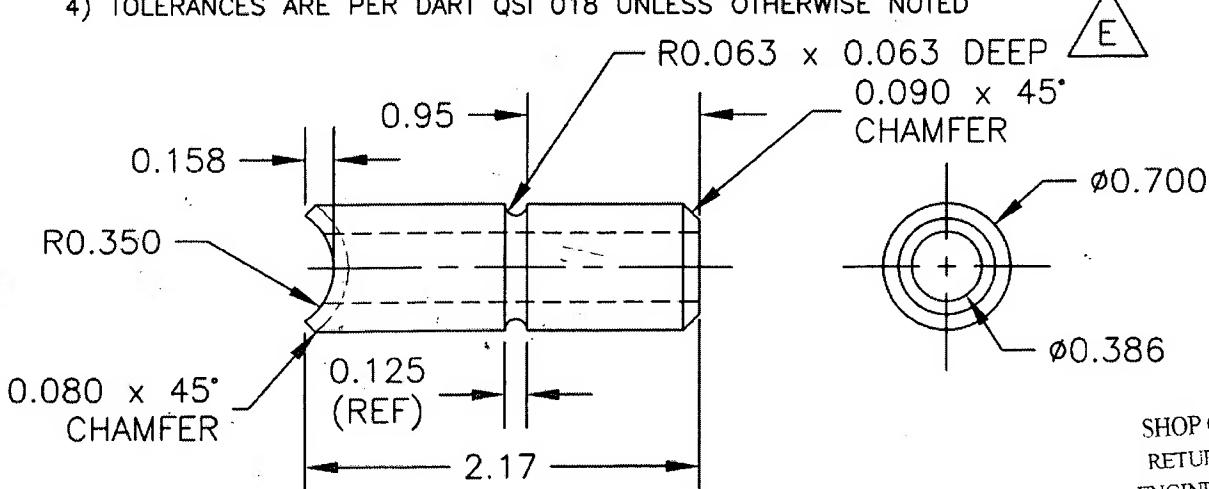
D

D2282-7



D2282-3/7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D

D2282-5

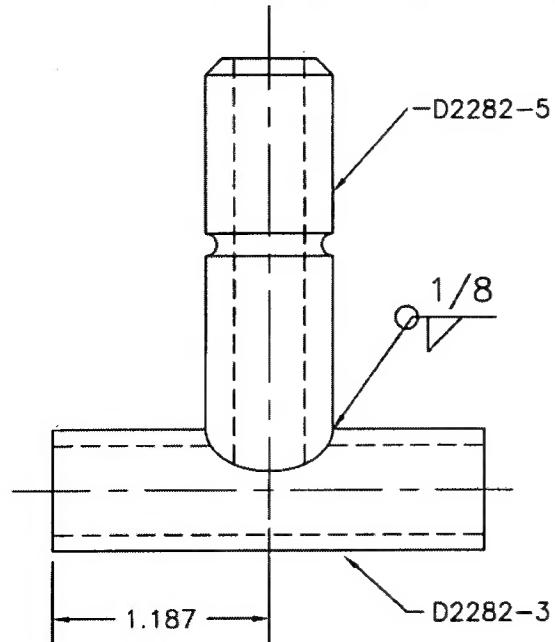
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJ: *33260*

D2282-5 STEM:

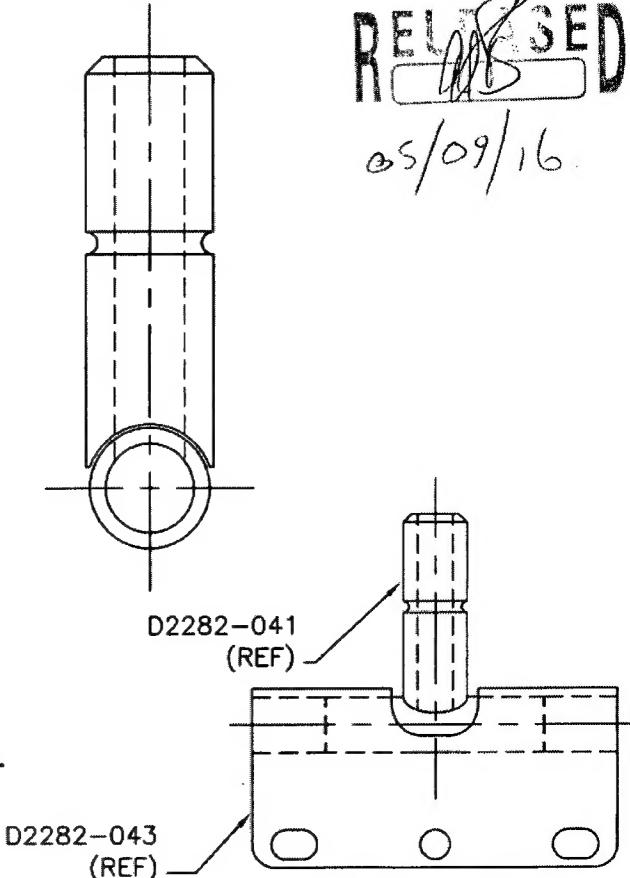
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

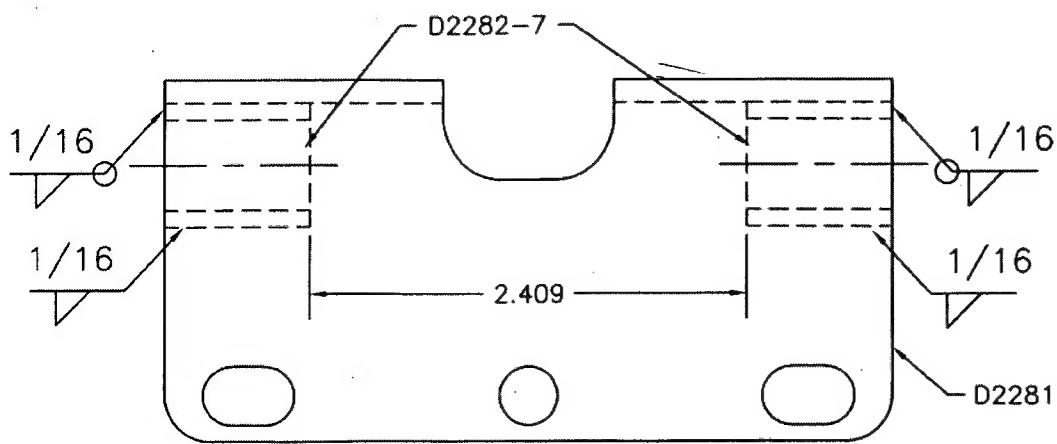
DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMEND
WITH JT NOTICE
WORK ORDER
NO. 33260